

Work Order ID 59927

Thursday, June 17, 2010 10:40:10 AM



Page 1

Item ID: D3929-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 6/17/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/24/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

[Handwritten signature]

Date: 10-6-17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3929

Rev A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3929

Dwg Rev: 4

Prog Rev: 4

2-Deburr if necessary

10-6-17

⑥

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-6-17

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

5/10/06/17

06

140



Large Fab

Large Fab

Memo

Weld bushings D3907-1 as per dwg D3929

316L rod batch: 111679

0.00

0.00

07.01
10.00

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

0100101

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Page 3

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Item Name: Gusset Assembly

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Cust Item ID:

Required Date: 6/24/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/07/01 01



170

Identify as per dwg & Stock Location: B/C

0.00



Packaging

Memo

0.00

Packaging

CPL 10-07-01

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/01 JF

MRF
10-7-01

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Picklist Print

Thursday, June 17, 2010 10:40:16 AM

Page 1

Work Order ID: 59927

Parent Item: D3929-041

Parent Item Name: Gusset Assembly



Start Date: 6/17/2010

Start Qty: 6.00

Required Date: 6/24/2010

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S11GA



304/316 0.125 Sheet

Purchased

No

100

sf

146.8059

0.45

2.842105



18106-17

Location

Loc Qty

Loc Code

MAT

146.8059

114488

18.8059

114799

128

114488

⑥

D3907-1



Bushing

Manufactured

No

130

Each

18.0000

2

12



Pl 10.06.30

Location

Loc Qty

Loc Code

WA

18

57937

18

3591836

④

⑫
⑧

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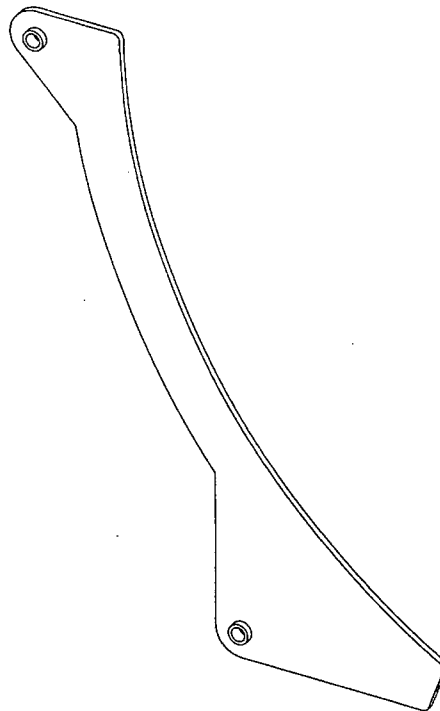
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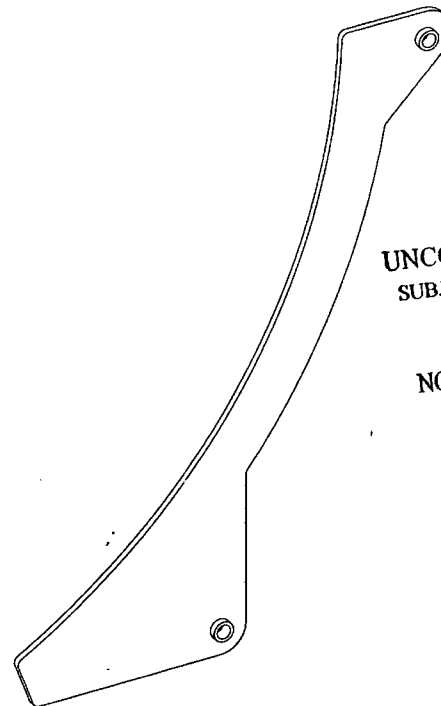
NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 59927
PS10-6-17



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

RELEASED
7/6/4/12 MB

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs EACH
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV. 1	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D3929	REV. A SHEET 1 OF 3
CHECKED		TITLE GUSSET ASSEMBLY	SCALE NTS
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APPROVED			
DE APPR.			
DATE	09.04.03		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

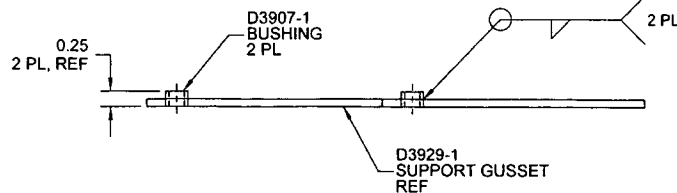
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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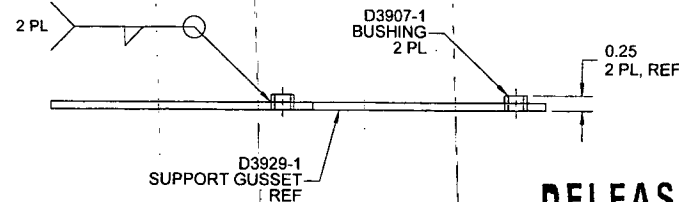
D3929-1
SUPPORT GUSSET
2 PL



D3929-041 GUSSET ASSEMBLY

w/o 59927

D3929-1
SUPPORT GUSSET
2 PL



D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
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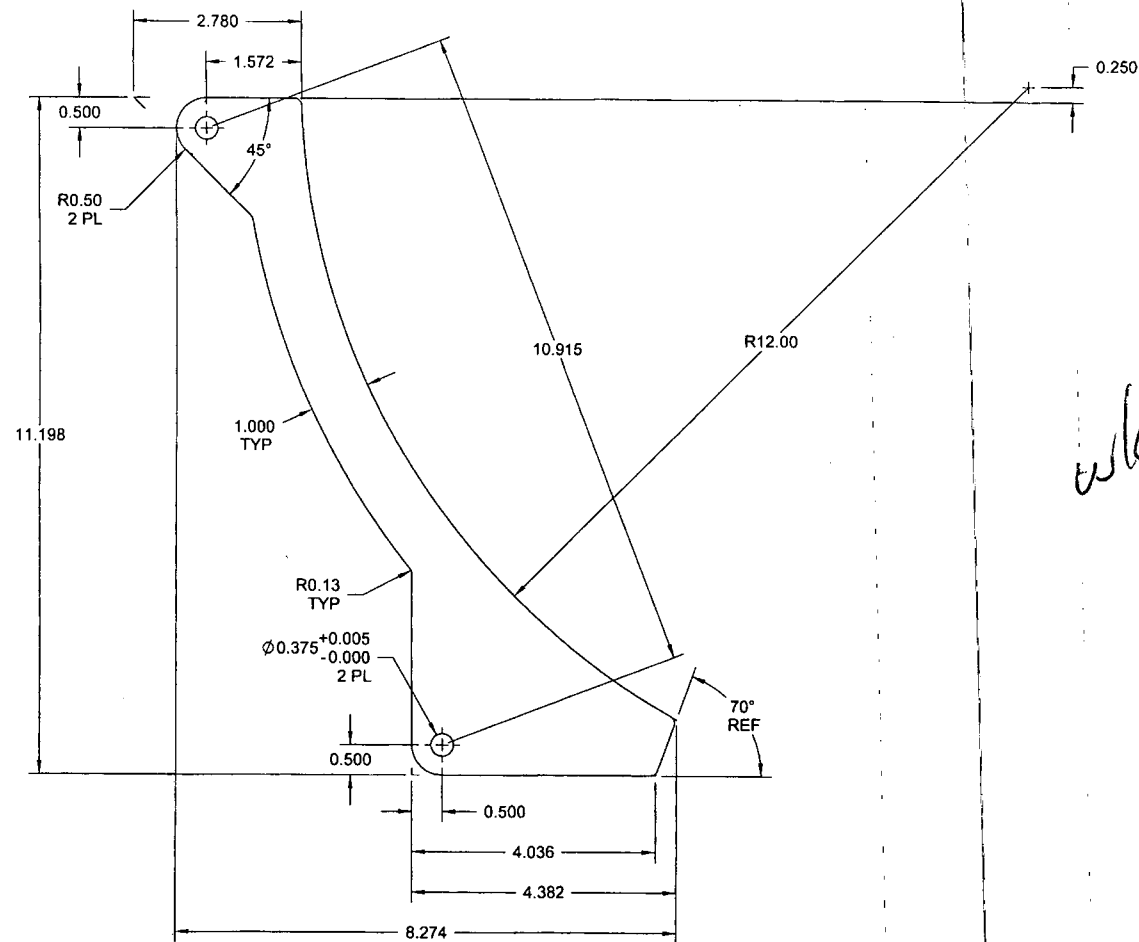
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D3929-1 SUPPORT GUSSET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

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MFG. APPR.		D3929	SHEET 3 OF 3
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09/04/22

WLO 59927

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